

# Work Order ID 86238

**\*86238\***

Page 1

June-25-12 10:32:44 AM

Item ID: D3537-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Wearpad

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/06/25

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100 0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr  
if necessary

304 .063

55 0 Jm 12-7-4

110 0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

55 0 Jm 12-7-4

120 0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Scrublog

counters  
(+55)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3537-1

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Setup Start **\*NS1\***

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Item Name: Wearpad

Start Date: 25/06/2012 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	NC BRAKE								
Brake NC	Memo	0.00				55x			12/07/12
Brake NC	I-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1								
140		0.00							
<b>*140*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch/A/R 2059B Hardcoat M122210 Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpadif necessary								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

(x55)

MAL 12/07/12

DAS 16

12/07/13

(x55)

W/O:		WORK ORDER CHANGES					
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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearpad

Start Date: 25/06/2012 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
170 <b>*170*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: FINISH TIME: OVEN TEMPERATURE:	0.00 0.00							
180 <b>*180*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							

DAS 16 8-83

12/01/13

cont  
AS

SSX ✓

ML  
12/07/16

M121274

3200F

9:00

SSV & 12/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 25/06/2012 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: F-PQ 0.00

\*190\*

Packaging

Memo

0.00

Packaging

SSX ~~✓~~ mf  
12/07/16

200

QC21- Final Inspection - Work Order Release 0.00

\*200\*

QC

Memo

0.00

Quality Control

12/7/18 MS  
12/07/16

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

June-25-12 10:32:48 AM

Page 1

Work Order ID: 86238

\*86238\*

Parent Item: D3537-1

\*D3537-1\*

Parent Item Name: Wearpad

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	1.5746	0.106	5.578947			

\*M304S16GA\*

304/316 Sheet .063

\*\*

Jm 12-7-4

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

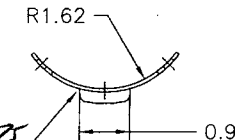
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

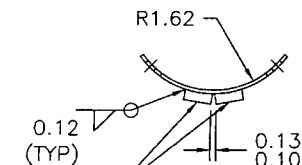
NO. 86238 HJ

SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

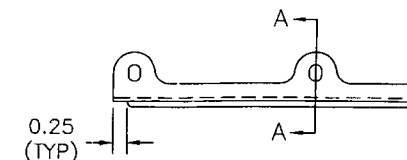
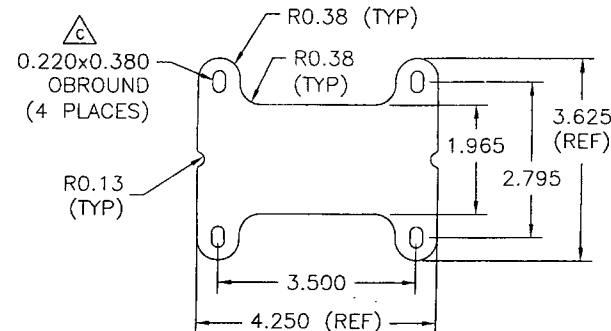
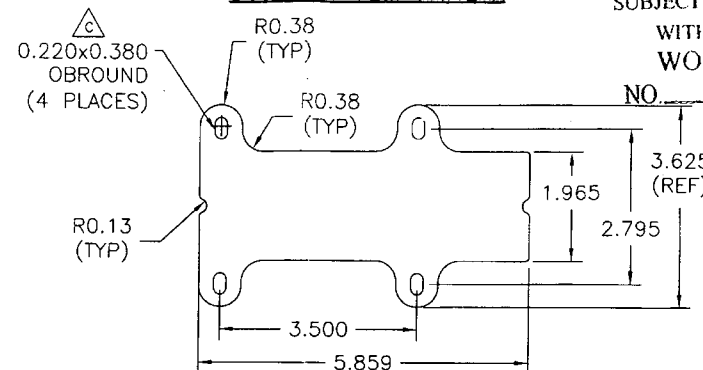
SECTION B-B



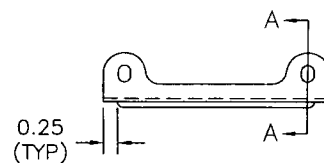
D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

**RELEASED**  
07.05.08 AH  
REV EGN 962

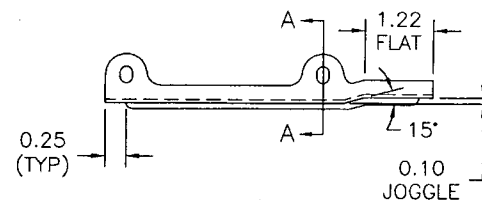
**D3537-7 LONGITUDINAL BEND**  
(MADE FROM D3537-3F)

**D3537-1F FLAT PATTERN****D3537-3F FLAT PATTERN**

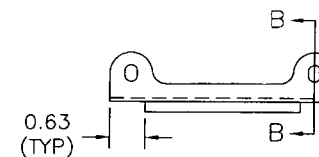
**D3537-1 LONGITUDINAL BEND**  
(MADE FROM D3537-1F)



**D3537-3 LONGITUDINAL BEND**  
(MADE FROM D3537-3F)



**D3537-5 LONGITUDINAL BEND**  
(MADE FROM D3537-1F)

**D3537-1/-3/-5/-7 WEARPAD NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

DART AEROSPACE USA, INC.

PORT HADLOCK, VA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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